

628.041

Work Order ID 55785

February 1, 2010 12:48:42 PM



Item ID: D2721-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 206B Step Assembly

Start Date: 2/02/10 Start Qty: 3.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D2721	Rev C
-------	-------

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2721-1 using D2622 extrusion as per Dwg D2721 Debur and bevel ends for welding

10.02.16

3 0

110

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT followed by Jig DT A/R AL Rod Batch: 1110130 Grind end cap welds flush

10.02.16

3 0

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

3 0 2E 10/02/17

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February 1, 2010 12:48:42 PM

Page 2

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Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

10/02/17

QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

10-02-17

HandFinish

Memo

0.00

Hand Finishing

150

QC3- Inspect Part Finish

0.00

10/02/17

QC

Memo

0.00

Quality Control

Work Order ID 55785

February 1, 2010 12:48:43 PM

Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Large Fab

Large Fab

Large Fab

Memo

Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg
D2721 using Jig DT followed by Jig DT A/R AL Rod
Batch: 1111311 Grind End Cap Welds Flush

0.00

0.00

10-02-17

3

0

170



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

3

0

FE 10/02/18

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 10/02/18

+3
41

3

0

FE 10/02/18

Work Order ID 55785

February 1, 2010 12:48:43 PM

Page 4

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Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BR 10-02-18

(3)

Memo

0.00

197



Powdercoat

Powder Coating

powder coat white per QSI005

0.00

0.00

BR. 10-02-18

(3)

Memo

m 113170.
START 3:15
OVENT. 3:20
FINISH. 3:45

198



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

AL 10/02/18

(13)

Memo

~~10-03-02~~

Work Order ID 55785

February 1, 2010 12:48:44 PM

Page 5

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Start Date: 2/02/10 Start Qty: 3.00

Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 3.00

Customer:

Reference:

Run Start

Approvals: Process Plan:

Date: Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

Pressure Wash per QSI005 4.3

0.00



HandFinish

Hand Finishing

11/02/24

WING WALK BAR 4.113462
Memo

0.00

10-02-24

(3)

230

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

10/06/24

(X3)

240

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

POP
56508

0.00

10/03/01 *(3)*

Work Order ID 55785

February 1, 2010 12:48:44 PM

Page 6

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Cust Item ID:

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Customer:

Reference:

Run Start

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/03/03

BS10-3-02

Picklist Print

February 1, 2010 12:48:41 PM

Page 1

Work Order ID: 55785

Parent Item: D2721-041

Parent Item Name: 206B Step Assembly


Start Date: 2/02/10

Required Date: 2/18/10

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-7  Mounting Plate		Manufactured	No			100	Each	34.0000	3.0000			

2/10.02.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

34

33863

34

3

D2622-120C  Step Extrusion		Manufactured	No			110	Each	48.7400	3.0000			
--	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

2/10.02.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

WA

48.74

48612

3.12

52026

45.62

3

D2734  Step End Plate		Manufactured	No			110	Each	79.0000	6.0000			
---	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

2/10.02.17

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

9

43535

2

48110

7

Main Warehouse

WA

70

55014

70

6

Picklist Print

February 1, 2010 12:48:41 PM

Page 2

Work Order ID: 55785



Parent Item: D2721-041



Parent Item Name: 206B Step Assembly

Start Date: 2/02/10

Required Date: 2/18/10

Comments: IPP Rev:F As Per Ecn 766 06-01-06 JLM

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3461-1 Mounting Plate		Manufactured	No			110	Each	13.0000	3.0000			

12 10.02.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

13

41600

13

3

D3461-3 Mounting Plate		Manufactured	No			110	Each	16.0000	3.0000			
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12 10.02.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

16

41601

16

3

D3461-5 Mounting Plate		Manufactured	No			110	Each	32.0000	3.0000			
-------------------------------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--

12 10.02.16

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST

32

33862

32

3

February 1, 2010 12:48:41 PM

Shop Packet Print

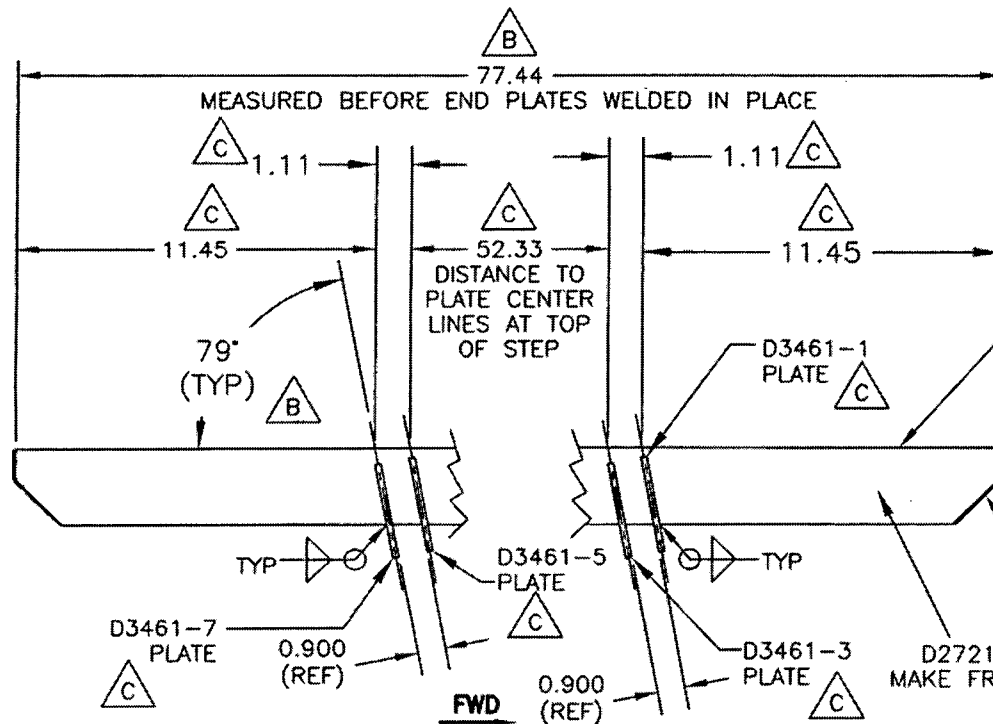
Page 2

RELEASED
05-11-14

APPLY BLACK
ANTI-SKID ON
- TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2721-1
MAKE FROM EXTRUSION D2622-078



D2721-041 LH STEP ASSEMBLY (SHOWN)
D2721-042 RH STEP ASSEMBLY (OPPOSITE)

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

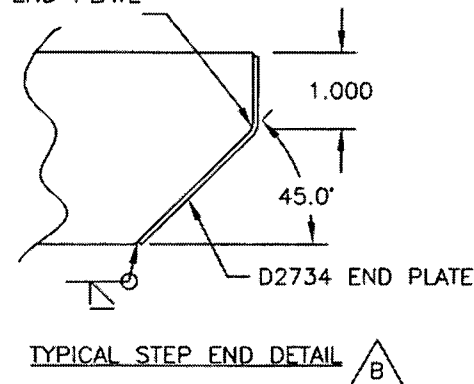
D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2721-041	LH STEP ASSEMBLY
	X	D2721-042	RH STEP ASSEMBLY
1	1	D2622-07B	EXTRUSION
2	2	D2734	END PLATE
1	1	D3461-1	PLATE
1	1	D3461-3	PLATE
1	1	D3461-5	PLATE
1	1	D3461-7	PLATE

D2721-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 *10-2-01*
- 2) WELD PER DART QSI 004 TYPICAL
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 55785
BS 10-201



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